

Split
Work Order ID 84628 -1

May-17-12 11:50:37 AM

Kush
84628

Page 1

Item ID: D3943-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Ground Handlling Crank Assembly

Start Date: 17/05/2012 Start Qty: 4.00 *4*

Required Date: 31/05/2012 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/05/12 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3943	E								

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Issue P/O: 17024
Purchase Part Number: 8143919
Supplier: Princess Auto
Certificate of conformity is required
Description: 4000 lbs lever chain hoist

CX 12/05/22 (6)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

12/05/22 (6)

Work Order ID 84628

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84628

Page 2

Item ID: D3943-041

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ground Handling Crank Assembly

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4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Large Fab

Memo

0.00

Large Fab

1-Disassemble chain host as per dwg

2-Drill handle ass'y (D3943-051) as per dwg

8/2/05/29

②

2 12-8-9

Work Order ID 84628

84628

Page 3

May-17-12 11:50:37 AM

Item ID: D3943-041

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N900040100

Setup Start ***NS1***

Revision ID:

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Item Name: Ground Handlling Crank Assembly

Start Date: 17/05/2012 Start Qty: 4.00

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Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5/26/12

180

Pick Kit

0.00

180

Packaging

Memo

0.00

Packaging

EX *EL* *12/07/12*

190

0.00

190

Large Fab

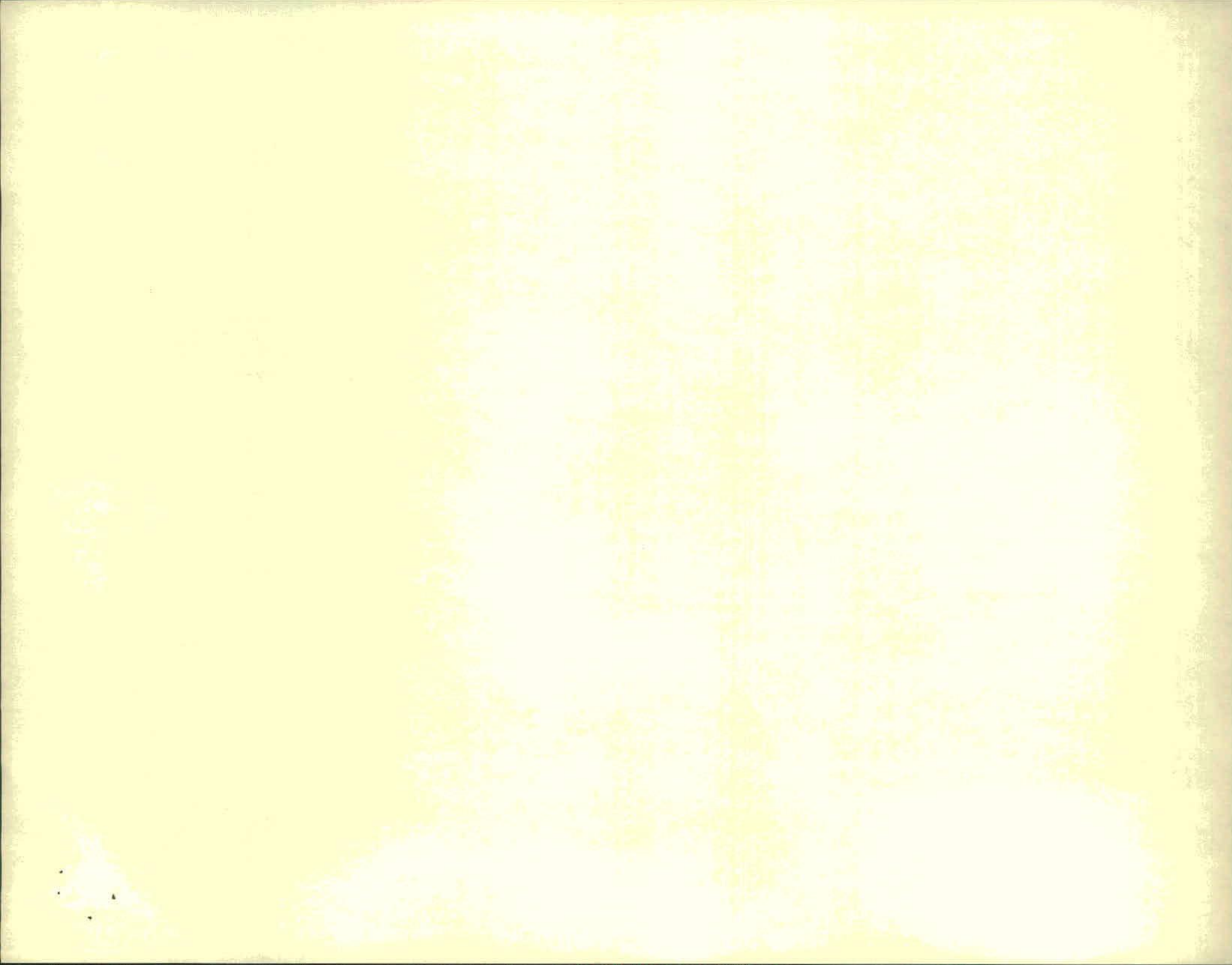
Memo

0.00

Large Fab

1-Assemble as per dwg
(assy landyard CBL-1240 to CBL-460)
2- touch up with paint if necessary

EX *EL* *12/07/12*



Work Order ID 84628

May-17-12 11:50:37 AM

84628

Page 4

Item ID: D3943-041

Accept

N900040100

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4

Cust Item ID:

Required Date: 31/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

1-Calibrate and tag as per dwg and QSI 008 4.4
Calibration Cert. filled out

CALIBRATION

ID D3943-041 B84628

BY S DATE 12/6/10

DUE per cert 1 year / service

210

Identify as per dwg & Stock Location:

0.00

210

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control



Per 12/8/10

12/8/10

MR 12-08-10

Picklist Print

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Page 1

Work Order ID: 84628

84628

Parent Item: D3943-041

D3943-041

Parent Item Name: Ground Handling Crank Assembly

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 09-06-02 EC Verified By: JLM
add DEO DD 09.11.18 verified by:JLM
REV.C DD 10.02.22 verified by:EC
REV.E DD VERF:JLM
IPP RevB:
IPP Rev:C as per dwg
IPP REV:D 11.08.16 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4405-1 *D4405-1* Eye and Fork Swivel		Manufactured	No			180	Each	14.0000	1	4			
									**			EL 12-8-9	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA			14					
					70986			5					
					78913			4					
					84352			5					
8143919 *8143919* Lever Chain Hoist		Purchased	No			110	Each	0.0000	1	4			
									**			84628 MF 12-08-10	
D3943-051 *D3943-051* Handle Assembly		Manufactured	No			180	Each	0.0000	1	4			
					85217 x 2				**			EL 12-8-9	
D3943-053 *D3943-053* Chain Assembly		Manufactured	No			180	Each	0.0000	1	4			
					85218 x 2				**			EL 12-8-9	
D3943-3 *D3943-3* Handle Extension		Manufactured	No			180	Each	9.0000	1	4			
									**			EL 12-7-30	

Location

st073

Loc Qty

9

Loc Code

78174

9

2

Picklist Print

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Page 2

Work Order ID: 84628

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

84628

D3943-041

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

CBL-1240

Purchased

No

180

f

404.4567

1

4

CBL-1240

Cable

**

Location

Loc Qty

Loc Code

GA

404.456659

113565

3.911789

119021

387.51147

119690

13.0334

CBL-460

Purchased

No

180

Each

836.0000

2

8

CBL-460

Loop Sleeve

**

Location

Loc Qty

Loc Code

GA

836

121574

836

D3585-1

Manufactured

No

180

Each

62.0000

1

4

D3585-1

Set Screw

**

Location

Loc Qty

Loc Code

GA

62

55705

62

D3949-041

Manufactured

No

180

Each

5.0000

1

4

D3949-041

Remove before Flight Flag Assembly

**

Location

Loc Qty

Loc Code

ST486

5

48280

5

385227 (12)

May-17-12 11:50:41 AM

Shop Packet Print

Page 2

Picklist Print

May-17-12 11:50:41 AM

Page 3

Work Order ID: 84628

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

84628

D3943-041

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

D3954-7

Manufactured No

180 Each 2.0000 1 4

D3954-7

Ratchet Lug

**

EL 12-7-26

Location

Loc Qty

Loc Code

ST097

2

80567

2

2

AN5-11A

Purchased No

180 Each 492.0000 1 4

AN5-11A

Bolt

**

EL 12-7-30

Location

Loc Qty

Loc Code

ST337

492

118191

13

119512

479

6

AN960-516

NAS1149F05639 Purchased

No

180 Each 68.0000 1 4

AN960-516

WASHER

**

EL 12-7-30

Location

Loc Qty

Loc Code

ST337A

68

M119546 x 6

110098

68

180 Each 1,509.000 1 4

MS21042L5

Purchased No

MS21042L5

Nut

**

EL 12-7-30

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

1009

116105

5

116548

43

117611

18

119109

943

6

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Shop Packet Print

Page 3

Picklist Print

May-17-12 11:50:41 AM

Page 4

Work Order ID: 84628

Parent Item: D3943-041

Parent Item Name: Ground Handling Crank Assembly

84628

D3943-041

Start Date: 17/05/2012

Required Date: 31/05/2012

Start Qty: 4.00

Required Qty: 4.00

S1475

Purchased

No

180

Each

7.0000

1

4

S1475

inventory

**

EL 12-7-30

Location

Loc Qty

Loc Code

ST396

7

117812

7

3408A59

Purchased

No

180

Each

3.0000

1

4

3408A59

BALL PLUNGER

**

EL 12-7-30

Location

Loc Qty

Loc Code

ST401

3

117829

3

M 12,5038 x 3

HX-15

Purchased

No

180

Each

73.0000

1

4

HX-15

1/4-20 UNCx3/4 S.H.C.S.

**

EL 12-7-30

Location

Loc Qty

Loc Code

Mezz

29

114383

29

ST390

44

117865

44

HX-16

Purchased

No

180

Each

203.0000

3

12

HX-16

**

EL 12-7-30

Location

Loc Qty

Loc Code

ST390

203

113271

68

117346

85

117865

50

May-17-12 11:50:41 AM

Shop Packet Print

Page 4

ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERRED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3643-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN980-518	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/2-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/2-20 UNC X 1.0 LG	HASKINS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 84628 NLS
12/05/17

RELEASED
2011-07-29

E	CHANGED D3945-3 MATL TO SS (B8-5); FINISH NOW "NONE" (A7-5); TAP DRILL FOR 1/4-20 UNF-2B WAS PILOT HOLE NOTE (B1-5). PER PAR11-113.	MB	11-07-27
D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED. SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2). ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5). ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1). PAR 10-001	CP	10/01/28
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09/10/16
A	NEW ISSUE	AJS	06/06/13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTON / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3943 TITLE GROSS WEIGHT TOW CRANK ASSY DATE 11.07.27 COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER EXPRESS AGREEMENT THAT IT IS NOT TO BE USED FOR ANY PURPOSE UNLESS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD</small>	
DRAWN			
CHECKED	ASS		
MFG. APPR.			
APPROVED			
DE APPR.	N/A	REV. E	SHEET 1 OF 5
		SCALE	N/A

REMOVE AND RETAIN
RUBBER HAND GRIP

DISCARD PIN

RETAIN PIN

REMOVE &
DISCARD HOOK

8143919 LEVER CHAIN HOIST
(SHOWN PRIOR TO MODIFICATION)
(CHAIN SHOWN SHORTENED FOR CLARITY)

8143919
LEVER CHAIN HOIST

(CHAIN NOT SHOWN FOR CLAIRTY)

AN5-11A BOLT
AN980-516 WASHER
MS21042L5 NUT

3408A59
BALL PLUNGER

RE-INSTALL
RUBBER HAND-GRIP
HERE

D3943-3
HANDLE EXTENSION

D2690-4 LANYARD

△ D3949-041 FLAG

HX-16 S/H CAP SCREW

HX-15 S/H CAP SCREW
S-1475 SPRING

CALIBRATION TAG

D3585-1 SET SCREW

RE-INSTALL PIN

D3943-053 CHAIN ASSY

(CHAIN SHOWN SHORTENED FOR CLAIRTY)

D3943-041 GROUND HANDLING CRANK ASSEMBLY

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE

DSTON / AJS

ASS

ASS

N/A

N/A

11.07.27

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3943
TITLE GROSS WEIGHT TOW CRANK ASSY
REV. E
SHEET 2 OF 5
SCALE
NTS

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NOTES -041:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3943-041" USING FINE POINT PERMANENT INK MARKER
- 7) CALIBRATION TAG PER DART QSI 003 4.4 (ZN C1-2)

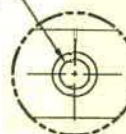
RELEASED
2011-07-29

D3943-1 HANDLE

2 PL

9.75

2.00

Ø0.31
THRUD3943-7 STUD
2 PLTHREAD 1/4-20 UNC-2B
THRUVIEW-A-A
AS-3
(SCALE: 2X) BS-39.38
REF

A B1-3

D3943-5 PLATE

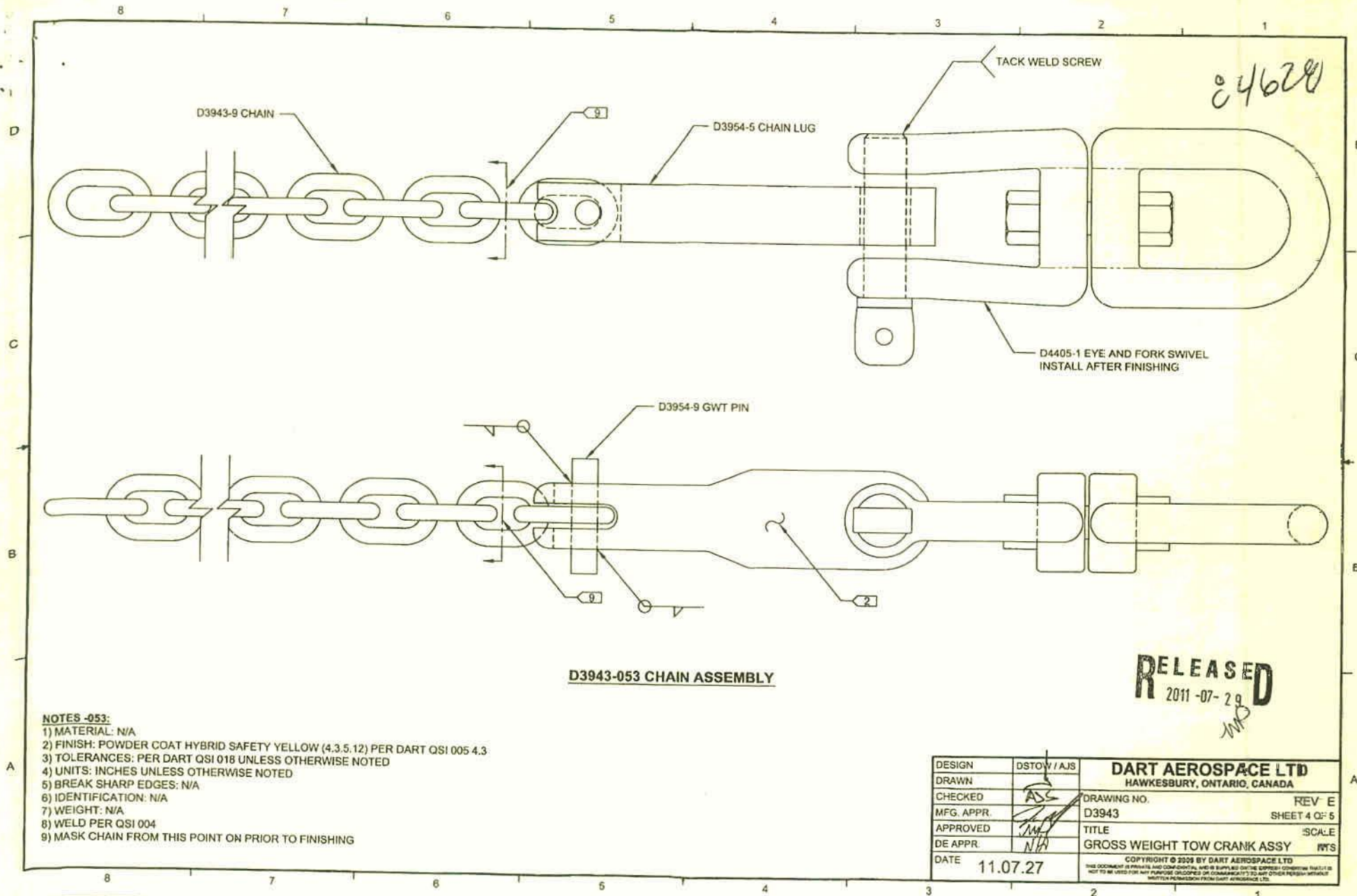
A B1-3

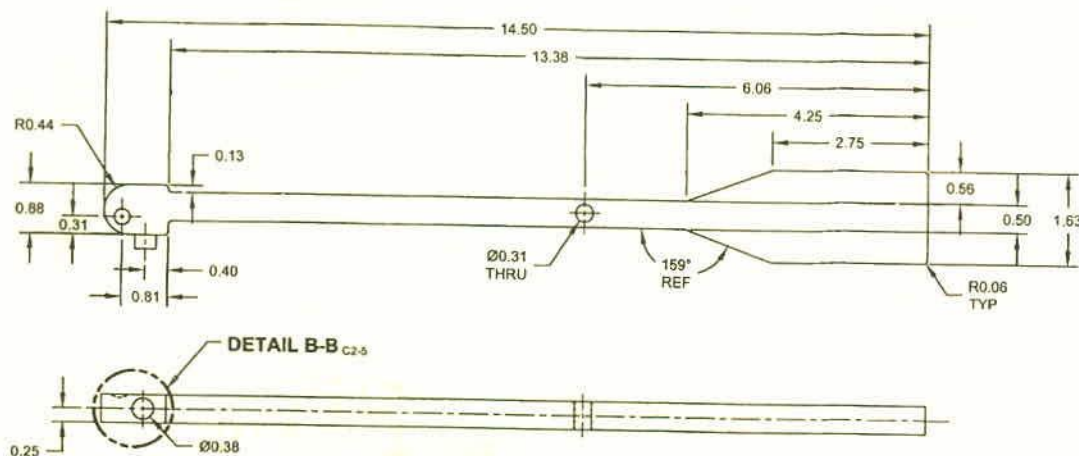
D3943-051 HANDLE ASSEMBLY**NOTES -051:**

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (#3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.08 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO FINISHING

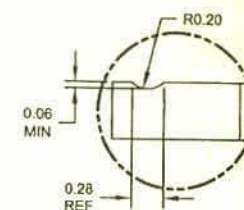
RELEASED
2011-07-28
MM

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV E
MFG. APPR.		D3943	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NT
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D3943-3 HANDLE EXTENSION



DETAIL B-B C7-5
(DIMPLE DETAIL)
(SCALE 2X)

NOTES:

1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S

OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A368/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S

OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A368/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: NONE

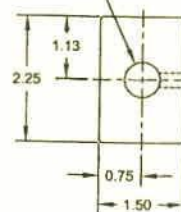
3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

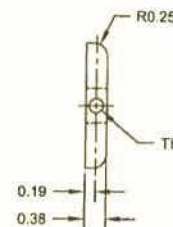
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

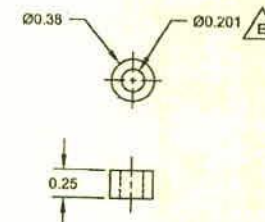
THREAD $\frac{1}{8}$ -11 UNC-2B



D3943-5 PLATE



THREAD $\frac{1}{8}$ -28 UNF-2B



D3943-7 STUD
(SCALE 2X)

RELEASED
2011-07-28

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.	WJS	D3943	SHEET 5 OF 5
APPROVED	WJS	TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17024

Purchase Order Date 5/22/12

PO Print Date 5/22/12

Page Number 1 of 1

Order From :

VC-PRI001

PRINCESS AUTO LTD.
P.O. BOX 1005
WINNIPEG, MB R3C 2W7
CA

Contact Name

Vendor Phone

613 247 1651

Vendor Fax

613 247 1657

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	8143919	Lever Chain Hoist	5/25/12 Yes	6.00 Each	Day & Ross coll	\$159.9900	\$959.94

Special Inst: AS PER DWG D3943 REV. E
B84628
PRINCESS AUTO P/N: 8143919 4000LBS
LEVER CHAIN HOIST

PO Total: \$959.94

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 3

Change Date: 5/22/12

order # 19036795

From

E-FULFILLMENT CENTRE
8620 ESCARPMENT WAY
MILTON ONTARIO
L9T 0M1

To

DART AEROSPACE
1270 Aberdeen St

Hawkesbury ON
K6A 1K7 CAN
613-632-5200

Order Number 000290310010000
Parcel Weight 181.340

Parcel Number 02488411
PP#: 96618

ASCENT Parcel #

BOSS Parcel #



OTHER

Container: EFC

Item	Description	Qty Shipped
8143919	HOIST CHAIN 2 TON LEVER	6

***** THIS IS NOT AN INVOICE *****

* Thank you for your order - shipping status is available at princessauto.com *

* Questions? Comments? 1-800-665-8685 *

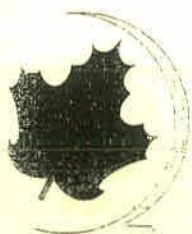
* Merci d'avoir passé votre commande chez Princess Auto! *

* Contactez-nous: 1-800-665-8685 *

* Vous pouvez utiliser votre numéro de commande ou les 4 derniers *

* chiffres de votre numéro de téléphone pour faire un suivi de votre colis. *

Alain Leclair MAIL MAN
613 - 632 6848
Receive Damage.



THE UNIQUE WORLD OF
PRINCESS AUTO

INTERNAL CALIBRATION CERTIFICATE

Instrument #	Description	Serial #
D3943-041	Ground Handling Crank Assembly	B84628

Calibrated by	Date of calibration	Calibrated with	Due	Certificate #
ED	August 10th, 2012	Eng-07		
		25000LBS load cell		

New tool	Disposed	In Repair	On Hold	Being Calibrated

Employee	Department	Comments:
N/A	N/A	MUST BE CALIBRATED WITH IN 1 YEAR OF PURCHASE OR FIRST OPERATION

Spec.	Tolerance is + /-	Result	Pass Fail
3500LBS	3500-3700LBS	3600LBS	PASS

Entered By:
Eric Downing QC Coordinator

DAS
16
8-08 *7/10/10*

REFERENCE ONLY